

Work Order ID 73890

RH



Friday, September 16, 2011 3:28:45 PM

Page 1

Item ID: D206-642-151

Revision ID:

Item Name: Replacement Skidtube

Start Date: 9/16/2011 Start Qty: 1.00

Required Date: 10/21/2011 Req'd Qty: 1.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan: *MF*

Date: *11-09-19*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3804

A

IIN-D206-642

O

100



0.00

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-642-151

CHG001

N/A *[Signature]*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804

3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty ☐ Part Number ☐ Description ☐ Batch

A/R ☐ Aluminum Rod ☐ M12860

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg D3804 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804

7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt8166 & DT8169D & DT9771.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time.

> DC/SP

11/09/20

DP 11-9-20

> B 11/09/22

} OK 11/09/22

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D3804

15-C'sink GHW rivet holes as per Dwg D3804

16- Open Aft cap hole #6.
****no wearplate holes for this skidtube****

17-Deburr tube and blow out chips from inside the tube

11/01/22

11-2-22

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

8/10/22

FD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Dart Aerospace Ltd

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

1 0 BB 11/09/23

180



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: 9:29 Time: 11/09/23
Finish Date: 11/10/09 Time: 7:00 AM

Pick:

Qty ☐ Part Number ☐ Description ☐ Batch
A/R ☐ Sikaflex-291 ☐ M 118393 ☐
Sikaflex expire date: 12/04/05

DP 11-9-22

BB 11/09/22

Dart Aerospace Ltd

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Start Date: 9/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 10/21/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Quality Control

Memo

0.00

8 11/29/26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Stop



Start Date: 9/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 10/21/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200



Skidtubes

Skidtubes

Skidtubes

0.00

Memo

0.00

1-remove alodine from around hole and prepare for welding

m/s

11-9-26

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty ☐ Part Number ☐ Description ☐ Batch

A/R ☐ Aluminum Rod ☐ *m117884*

BE 11/10/04

BB 11/10/04

3-Grind welds flush as per Dwg D3804.

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.402" before welding other side. Use SS rod as required.

A/R ☐ SS Rod ☐

None

11/10/04

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr

DD

11-10-5

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 73890

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Item ID:	D206-642-151	Accept		Setup	Start	
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Start Date:	9/16/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	10/21/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 HandFinish Hand Finishing	HandFinishing Memo Install D2680-041 Nut Plate as per Dwg D3804	0.00 0.00							
					11-10-5				
220 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00							
					11.10.05				
230 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							

W/O:		WORK ORDER CHANGES					
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Work Order ID 73890

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Item ID: D206-642-151

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Setup Start



Revision ID:

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Start Date: 9/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 10/21/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	Pressure Wash per QSI005 4.3	0.00							
	HandFinish								
Hand Finishing	Memo	0.00							
250	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
	Powdercoat								
Powder Coating	Memo	0.00							
	START TIME: 3:00								
	OVEN TEMPERATURE: 320								
	FINISH TIME: 3:30								
260	QC3- Inspect Part Finish	0.00							
	QC								
Quality Control	Memo	0.00							

1. SR 11-10-06

1X PM 11/10/06

1 RH 11/10/11

M118439

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 9/16/2011 Start Qty: 1.00



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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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270

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive.

1 R14 1 11/10/11

280

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

✓ R ☐ Sikaflex-291 ☐ M11834B

Sikaflex expire date: ☐ 12/05

2- Install wearplate as per dwg

2-Wing Walk as per Dwg D3804 and QSI 005 4.4

Batch: M118313

1 11/10/11

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
290 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
			8/16/12						
300 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
			8/16/12						
310 Packaging Packaging	Packaging Memo	0.00 0.00							
	Identify and pack for shipping as per PPP D206-642-151								
	Location: _____								
	PPP Rev: _____								
	PPM 44/12								

cl
PM

8/16/12

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
320	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

n/10/18
MF
11-10-18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____ / _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

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Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube




Start Date: 9/16/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10.12.08 PER IIN REV.N DD VERF:EC
REV:B 11.09.16 PER IIN REV.O DD VERF:EC IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status																																																																																				
D2620  Skidtube, 206 Skidtube		Manufactured	No			110	Each	12.0000	1	1																																																																																							
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68136	1																																																																																																
71616	5																																																																																																
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D2647  Cap		Manufactured	No			110	Each	44.0000	1	1																																																																																							
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LG002	44																																																																																																
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71171	30																																																																																																
CR3212-4-04  Cherry Rivet		Purchased	No			180	Each	1,655.000	52	52																																																																																							
<table border="0"> <tr> <td><u>Location</u></td><td><u>Loc Qty</u></td><td><u>Loc Code</u></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td></tr> <tr> <td>ST311</td><td>1655</td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td></tr> <tr> <td>116471</td><td>78</td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td></tr> <tr> <td>117816</td><td>477</td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td></tr> <tr> <td>118686</td><td>100</td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td></tr> <tr> <td>118840</td><td>1000</td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td></tr> </table>														<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>												ST311	1655													116471	78													117816	477													118686	100													118840	1000												
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118840	1000																																																																																																

52

11-9-22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, September 16, 2011 3:28:40 PM

Page 2

Work Order ID: 73890

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 9/16/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

D2654-1

Manufactured No

180 Each

6.0000

1 1



Web

Location

Loc Qty

Loc Code

LG

6

73790

64562

6

D3286-1

Manufactured No

180 Each

32.0000

2 2



Doubler

Location

Loc Qty

Loc Code

LG002

32

52844

11

64563

21

D2649

Manufactured No

200 Each

289.0000

19 19



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

6

68224

2

71355

2

72704

2

LG001

283

65317

1

68507

11

73390

271

D3286-3

Manufactured No

200 Each

27.0000

2 2



Spacer

Location

Loc Qty

Loc Code

LG002

27

64564

27

Friday, September 16, 2011 3:28:40 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Friday, September 16, 2011 3:28:40 PM

Page 3

Work Order ID: 73890

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 9/16/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

D2680-041 Manufactured No

210

Each

19.0000

1

1



Nut Plate



SAD 11-10-05

Location

Loc Qty

Loc Code

ST020

19

55366

17

70088

2

B73334

①

CR3212-4-03

Purchased No

210

Each

1,138.000

2

2



Cherry Rivet



SAD 11-10-05

Location

Loc Qty

Loc Code

FP-B

2

110139

2

ST311

1136

114859

1136

②

AN960JD416

NAS1149D0463J

Purchased No

210

Each

0.0000

1



Washer

11118384



all 11-10-11

CCR264SS3-3

Purchased No

210

Each

435.0000

2

2



Cherry Rivet



SAD 11-10-05

Location

Loc Qty

Loc Code

FP-B

2

113973

2

ST311

433

117086

23

117849

410

②

Friday, September 16, 2011 3:28:41 PM

Shop Packet Print

Page 3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Friday, September 16, 2011 3:28:41 PM

Page 4

Work Order ID: 73890

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 9/16/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06

Purchased No

210

Each

29.0000

1



Screw



1
9/16/11

Location

Loc Qty

Loc Code

FP-A

8

115460

8

ST292

21

115460

21

D2651-1

Manufactured No

270

Each

289.0000

6



Plug



6
9/16/11

Location

Loc Qty

Loc Code

fpa

109

69018

109

FP-A

180

57869

1

66445

10

67760

36

70691

100

70839

2

71037

31

D2651-3

Manufactured No

270

Each

799.0000

6



O-Ring



6
9/16/11

Location

Loc Qty

Loc Code

FP-A

799

61962

12

66956

282

73489

505

9/16/11

Friday, September 16, 2011 3:28:41 PM

Shop Packet Print

Page 4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Friday, September 16, 2011 3:28:41 PM

Page 5

Work Order ID: 73890

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 9/16/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

D3873-1

Manufactured No

280

Each

160.0000

14

14



Bushing



xl ul 10/16

Location

Loc Qty

Loc Code

ST084

4

B73029

xl

68247

4

ST088

156

64760

1

70690

54

71837

101

D2646

Manufactured No

280

Each

89.0000

1

1



Aft Cap



xl ul 10/16

Location

Loc Qty

Loc Code

FP004

45

68280

45

FP006

5

62678

5

FP-4

35

70945

1

71070

34

fp5

4

71038

4

D3805-041

Manufactured No

280

Each

0.0000

1

1



Wearplate Assembly Fwd, Low Gear

B73014



xl ul 10/16

Friday, September 16, 2011 3:28:42 PM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Friday, September 16, 2011 3:28:42 PM

Page 6

Work Order ID: 73890

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 9/16/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-08

Purchased

No

280

Each

1,296.000

2

2



Screw



Handwritten: 2 11/10/11

Location

Loc Qty

Loc Code

ST291

1296

115108

96

117423

300

118378

400

118910

500

Handwritten: 1/2

MS21042L3

Purchased

No

280

Each

2,603.000

7

7



Nut



Handwritten: 7 11/10/11

Location

Loc Qty

Loc Code

ST300

2603

117441

24

117601

374

117885

205

118451

1000

118927

1000

Handwritten: 1/2

D3805-045

Manufactured

No

280

Each

6.0000

1

1



Wearplate Assembly Aft, Low Gear

Handwritten: *

Handwritten: B 73816



Handwritten: (x1) 11/10/11

Location

Loc Qty

Loc Code

FP

6

70878

6

AN960JD10L

NAS1149D0332J

Purchased

No

280

Each

0.0000

2

2



Washer



Handwritten: B 73816 2117087

Handwritten: (x2) 11/10/11

Friday, September 16, 2011 3:28:42 PM

Shop Packet Print

Page 6

Dart Aerospace Ltd

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NOTE: Date & initial all entries

Picklist Print

Friday, September 16, 2011 3:28:42 PM

Page 7

Work Order ID: 73890

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 9/16/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

AN3-37A

Purchased

No

280

Each

261.0000

7

7



Bolt



Handwritten signature

11/10/11

Location

Loc Qty

Loc Code

ST353

211

111668

111

118628

100

ST354

50

117619

50

Handwritten signature

11/10/11

NAS1149D0363J

Purchased

No

280

Each

2,623.000

7

7



Washer



Handwritten signature

11/10/11

Location

Loc Qty

Loc Code

ST298

2623

117601

308

118077

1315

118612

1000

Handwritten signature

11/10/11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

73890

RELEASED
09.03.09
per Ecn 09-536

A	NEW ISSUE	MB	08.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	97	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 1 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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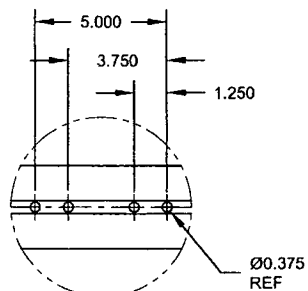
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

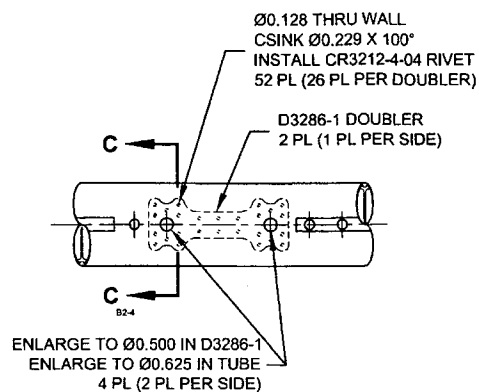
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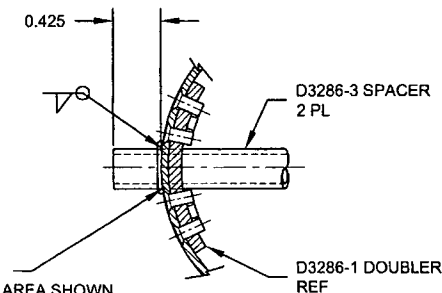
RELEASED
09.03.03



DETAIL A
SCALE NONE
D6-2
C2-2
D6-3
C2-3

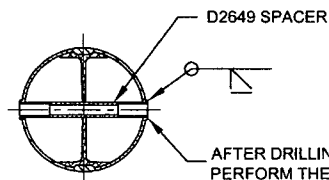


DETAIL B
SCALE NONE
C3-2
C3-3



- TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

SECTION C-C
PARTIAL SECTION
SCALE NONE
C6-4



- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

SECTION D-D
FOR Ø0.375 HOLES ONLY
SCALE NONE
A4-2
A4-3

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	97	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 4 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07	<small>COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR REPRODUCED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

73590

W/O:		WORK ORDER CHANGES					
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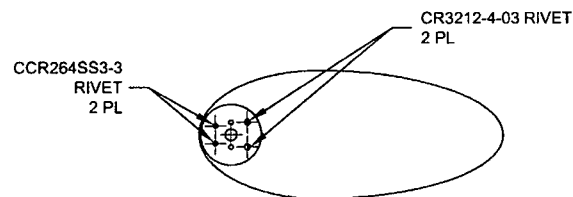
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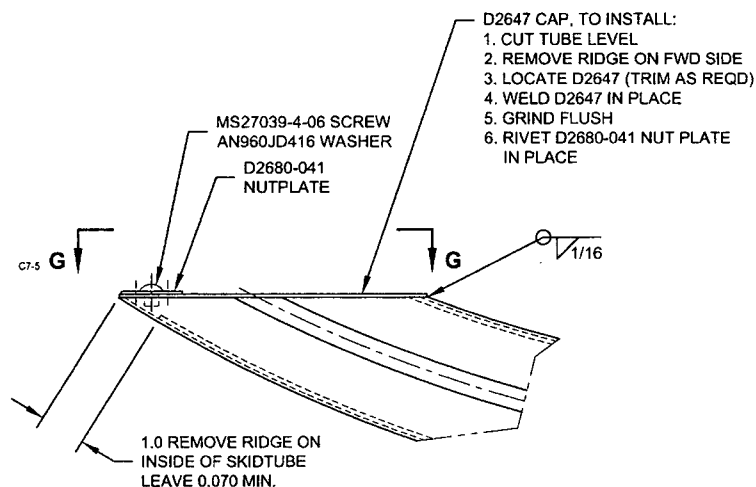
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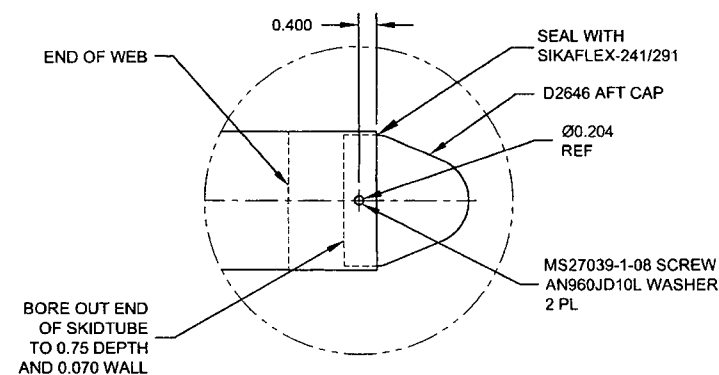
RELEASED
09.03.03



VIEW G-C
SCALE NONE A7-5



DETAIL E
SCALE NONE B7-2 B7-3



DETAIL F
SCALE NONE B2-2 B2-3

#73890

DESIGN	99	DART AEROSPACE USA, INC	
DRAWN	99	PORT HADLOCK, WA	
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 266

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 704089
Part number: 5206 642 151
Description: 206
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Lat. Lynn Date of Test Coupon 11-09-22

Welder Barclay Elliott Date of Test Coupon 11-09-22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld